

Work Order ID 67987

Tuesday, April 05, 2011 10:33:05 AM

Page 1

Item ID: D4380-1
Revision ID: PRELIM
Item Name: Oxygen Pocket

Accept

Setup Start

Stop

Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00

Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: MF Date: 11-04-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4380	<u>PAG 007 12 11/04/ A 9/</u>

100	0.00
-----	------



HandThermo	Memo	0.00
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size	

105	0.00
-----	------



HandThermo	Memo	0.00
Hand Finishing Thermoforming	Dry Sheet as per QSI022 Kydex	

Temp: 150°
Time IN: 6:00 PM 11/04/05
Time OUT: 7:00 AM 11/04/06

B 11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA110 using tool DT9735

Dwg Rev: PA7

Folio Rev: A

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Visually inspect part for proper formation and texture

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

11/04/06

11/04/06

11/04/06

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Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

DL
11/04/06

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

RB
11/04/06

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

*- inspect to Part**Don only**Subtotal**PK*

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: Recall

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD2370

POSITIVE RECALL

EFFECTIVE 11/15/13

RELEASED W

AUTH U

DATE 11/15/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:33:01 AM

Page 1

Work Order ID: 67987



Parent Item: D4380-1



Parent Item Name: Oxygen Pocket

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

787.2912

116576

3.46875

DL
11/04/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 , Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

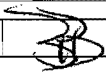
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DART AEROSPACE LTD		Work Order: 67987
Description: Oxygen Packer		Part Number: D4380-1
Inspection Dwg: 4380-1	Rev: PA7	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION


Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: 


Date: 11/09/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.0	.100	12.0	✓		Tape (H.O.)	
13.5	.100	13.55	✓		TH.O.S	
10.0	.100	10.0	✓		TH.O.S	
8.0	.100	8.0	✓		TH.O.S	

Measured by: 

Date: 11/09/06


Audited by:  to PA7 Day

Date: 11/09/07

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

 10.04.14

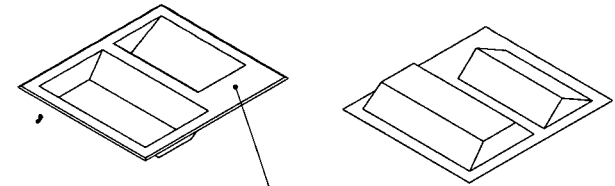
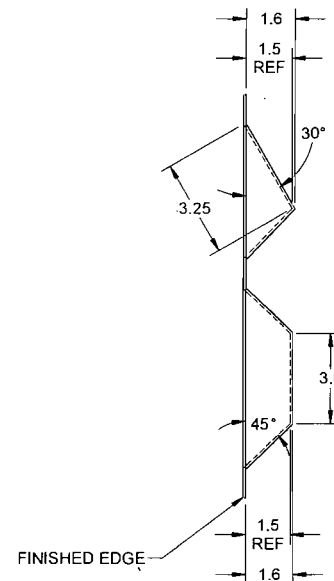
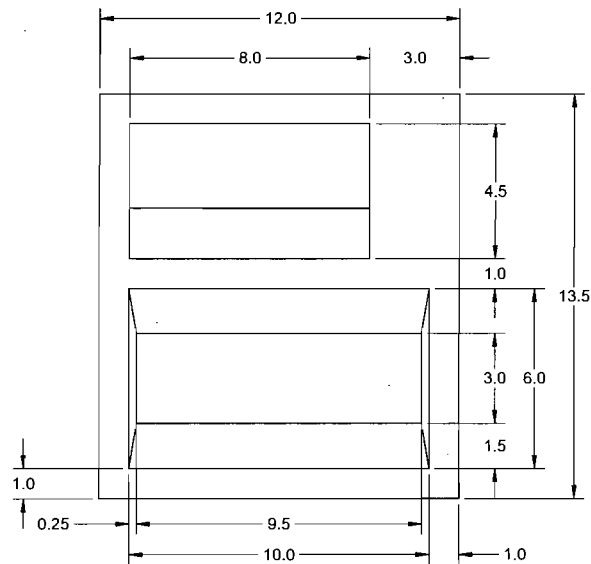
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NOTE: Date & initial all entries



TEXTURED SIDE

FINISHED EDGE

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.80 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -1 PART PER MOULD DT9735.
TRIM PER MOULD LEAVING FINISHED EDGE.

D4380-1 OXYGEN POCKET

PRELIMINARY ISSUE

DL 11.04.05

PA7	NEW ISSUE	DC	11.04.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DL</i>		
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 1 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
DATE	11.04.05	<small> COPYRIGHT © 2011 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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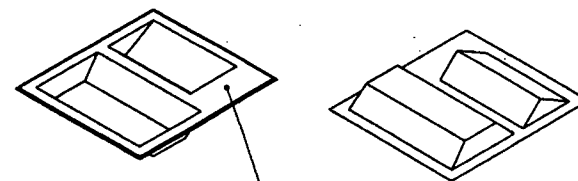
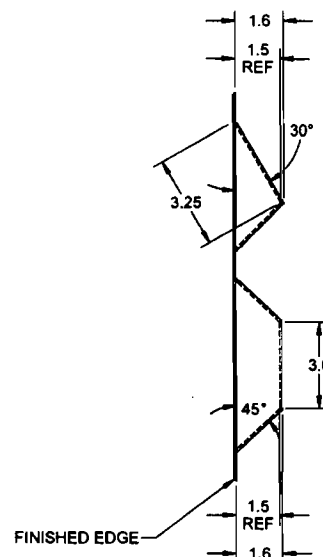
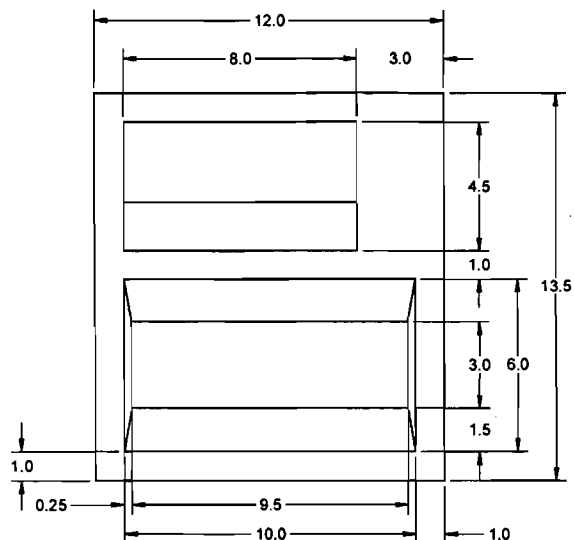
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



TEXTURED SIDE

67987

RELEASED
2011-05-10

D4380-1 OXYGEN POCKET

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.80 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9735 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

A		NEW ISSUE		DC		11.04.21	
REV.		DESCRIPTION			BY		DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A SHEET 1 OF 19 SCALE NTS		
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.		DRAWING NO. D4380			TITLE CEILING POCKETS		
DATE		11.04.21			COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

